

Date: Thursday, 2/14/2008 11:01:39 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	LABEL PLATE		
Job Number	37446			Part Number	D2506		
Estimate Number	10599			Drawing Number	D2506 REV E		
P.O. Number				Project Number	N/A		
This Issue	2/14/2008	S.O. No.		Drawing Revision	E		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	2/25/2008	Qty:	20
Previous Run	35585			Um:	Each		
Written By	<u>JH</u> 02/14						
Checked & Approved By							
Comment	Est. B	01.06.08	Now laser cut EC				
	est C	06.12.13	ecn 822 ec				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S20GA	304/316 .040 Sheet	
	Comment: Qty.: 1.2810 sf(s)/Unit Total : 25.6200 sf(s) 304/316 .040 Sheet Batch: 106748	<u>B 8-2-21</u>	<u>20</u>
2.0	WATER JET	FLOW WATER JET	
	Comment: FLOW WATER JET 1-Cut as per Dwg D Dwg Rev: <u>F</u> Prog Rev: <u>E</u>	<u>B 8-2-21</u>	<u>20</u>
	2-Deburr if necessary	<u>B 8-2-21</u>	<u>20</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>B 8-2-21</u>	<u>20</u>
4.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK	<u>20802-25</u>	<u>20</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
	Comment: SMALL & MEDIUM FAB RESOURCE 1	<u>N/A</u>	<u>Done 2 sec - 2.0</u>
	1-Deburr if necessary.		<u>J</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: J.D. Date: 20/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 11:01:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL PLATE

Job Number: 37446

Part Number: D2506

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2506

SS 08/02/27 20

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

P 08-02-27 20

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

H 08/02/27

Job Completion



2008/2/27

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37446
Description: Label Plate	Part Number:	D2506
Inspection Dwg: D2506 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

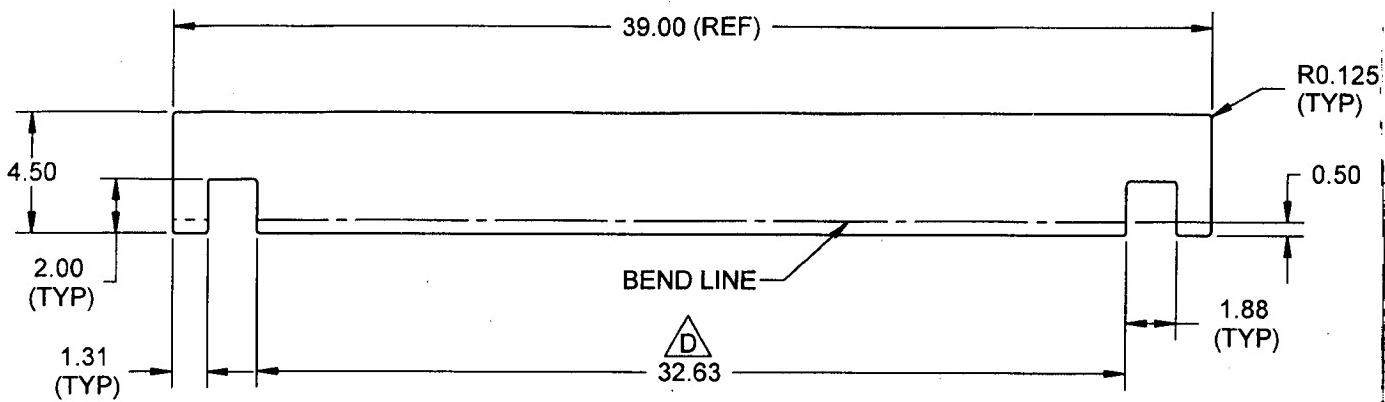
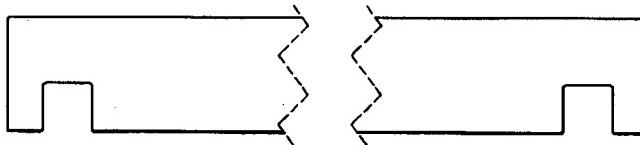
Measured by:	<u>BS</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	8-2-21	Date:	10-02-25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	
B	06.12.20	Dwg Rev. updated	KJ/JLM	
C	07.09.06	0.040 dimension added	KJ/JLM	Z

DART

DESIGN BW	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>MM</i>	DRAWING NO. D2506	REV. E	SHEET 1 OF 1
DATE 06.11.20		TITLE LABEL PLATE	SCALE	1:7
REV	DATE	DESCRIPTION		
A	95.11.26	NEW ISSUE		
B	96.06.18	RE-DESIGN OF LABEL PLATE		
C	96.09.04	RE-DESIGN OF LABEL PLATE		
D	99.10.04	32.63 WAS 32.25; 1.31 WAS 1.50		
E	06.11.20	REMOVE 10° BEND; ADD NOTES: 127° WAS 126°		

RELEASED

06.11.28 *MM***D2506F FLAT PATTERN****D2506 LABEL PLATE**

R0.08
127°
0.50
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
37446

**NOTES:**

- 1) MATERIAL: STAINLESS STEEL AISI 304/316 SHEET 0.040 THICK PER MIL-S-5019
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX